

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025222**Date Inspected:** 11-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG 12AE, 13AE**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Trial Assembly Yard

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding(SMAW), and Flux Cored Arc Welding(FCAW) process.

ZPMC QC is identified as Zhan Hai Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: I Rib Stiffener

PCMK: SEG3007AA

Weld Number: 106, 109

Welder: 216086

WPS-B-T-4113-TC-U4b-2

Component: I Rib Stiffener

PCMK: SEG3007AA

Weld Number: 099, 102

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Welder: 215553

WPS-B-T-4113-TC-U4b-2

Component: I Rib to FB

PCMK: SEG3007AH

Weld Number: 123, 125, 143, 144

Welder: 200113

WPS-345-SMAW-4G-FCM-R1

WR 20583

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08801 from ZPMC for Trial Assembly Yard. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG 12AE, & 13AE. The weld designations reviewed are as follows.

FB3009-001-125, 165, 164

SEG3007P-273~276

Paint Shop 2

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08798 from ZPMC for Paint Shop 2. This QA inspector performed ultrasonic testing (UT) verification of Bearing Block Castings after ZPMC had performed their UT inspection. The segment is identified as OBG Anchor Plate Bearing Blocks. The bearing block designations reviewed are as follows.

APBB1-083-02, APBB1-099-08, APBB1-100-14, APBB1-057-08

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
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Reviewed By:	Riley,Ken	QA Reviewer
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